

Work Order ID 106716 -2

September-11-13 11:34:16 AM

106716

Page 1

Item ID: D4154-041

Revision ID:

Item Name: Wearplate Assembly

Start Date: 9/11/13

Start Qty: 10.00

10

Required Date: 9/11/13

Req'd Qty: 10.00

10

Reference:

Accept

N9000040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

MLJ

Date: 13-09-13

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4154

E

100

0.00

100

Large Fab

Large Fab

Memo

0.00

1- on D4155-1, fill cut outs with hardcoat welding rod as per dwg D4154
DT9756

2059 B Hardcoat Welding Rod

BATCH#: m/26588 → 20596

2-weld D4155-1 to wearplate by positioning holes together as per dwg D4154
304 S.S. Welding Rod

BATCH #: m/26048

3-Transfer drill holes in bar

4- Use DT9684 to check fit after welding

5- Cut extra material on back end of wearplate if necessary

FG

me 13-09-26

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Page 2

Item ID: D4154-041

Revision ID:

Item Name: Wearplate Assembly

Start Date: 9/11/13 Start Qty: 10.00

Required Date: 9/11/13 Req'd Qty: 10.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

(6) B-09-27 (DAS) 09 2-89

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

(6) B-09-27 (DAS) 09 2-89

150

0.00

150

Small Fab

Memo

0.00

Small Fab

1- After finish, coat entire top (concave) surface as per note 11 on sheet 2 of 3
dwg D4154.

126667

6 0 0 AR 13-9-28

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Item ID: D4154-041

Revision ID:

Item Name: Wearplate Assembly

Start Date: 9/11/13 Start Qty: 10.00

Required Date: 9/11/13 Req'd Qty: 10.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

160

160

QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Memo

Set Up/
Run Hours

0.00

0.00

DAS

27

9-89

13 9 30

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

6

x6 d 21 13/09/30

170

170

Packaging

Packaging

Identify as per dwg & Stock Location: FP-002 0.00

Memo

0.00

180

180

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

HJ / 13-09-30

13-09-30

Picklist Print

September-11-13 11:34:16 AM

Page 1

Work Order ID: 106716

Parent Item: D4154-041

Parent Item Name: Wearplate Assembly

Start Date: 9/11/13

Required Date: 9/11/13

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 10.09.21 new issue DD verf:EC
DT9684 DD verf:EC IPP Rev:C 11.04.14 as per dwg revB DD verf:EC
IPP Rev:D 12.09.14 as per dwg revE DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4154-1		Manufactured	No			100	Each	16.0000	1	10			
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B107071 * 2

Location

WA001

Loc Qty

16

Loc Code

90368

4

97403

12

D4155-1

Bar		Manufactured	No			100	Each	20.0000	1	10			
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Location

WA001

Loc Qty

20

Loc Code

103296

10

96434

2

97404

8

+6

me 1309.26

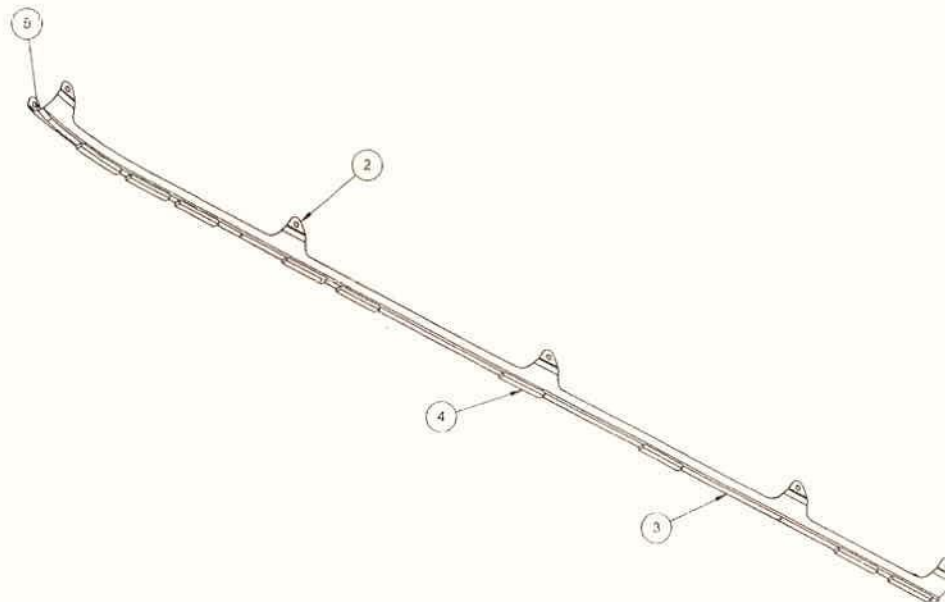
+4

+6

me 1309.24

+6

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4154-041	WEARPLATE ASSEMBLY
2	1	D4154-1	PLATE
3	1	D4155-1	BAR
4	A/R	2059B	HARDCOAT, (SEE NOTE 9, SHT 2)
5	A/R	4714	(SEE NOTE 11, SHT2)

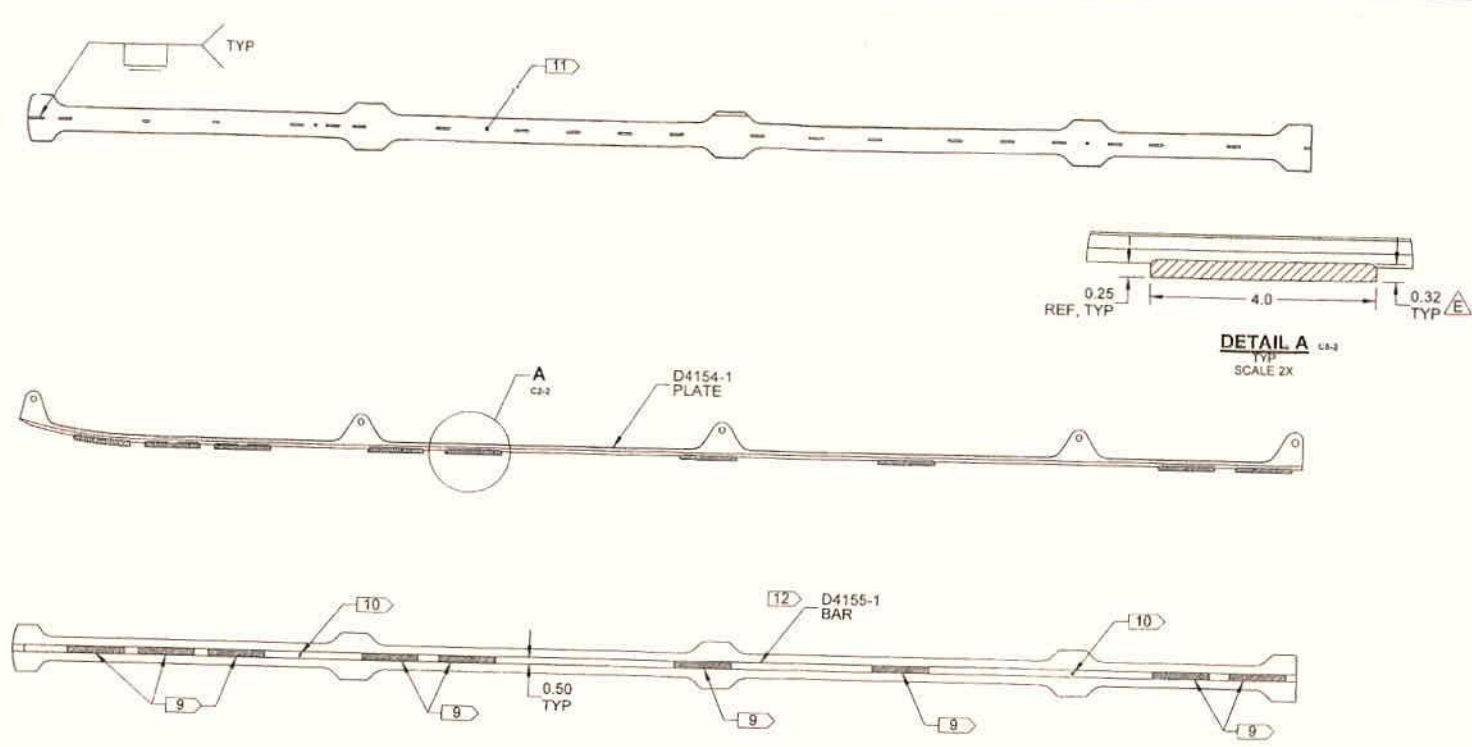


D4154-041 WEARPLATE ASSEMBLY

RELEASED
2012-09-04
WV

E	SHT 3 SLOTS RE-PITCHED (PAR 12-213); 0.32 WAS 0.37	AJS	12.08.07
D	70.45 WAS 74.45 & Ø0.188 HOLES NOW 2 PL (ZN C4-3 & C7-3)	RF	12.05.03
C	REVISE NOTE 9 (ZN A8-2); ADD HARDCOAT (ZN B7-2); ADD DETAIL A (ZN C2-2)	RF	12.02.21
B	ITEM 4 WAS PR1422 (D3-1); REMOVED FINISH TO NOTE 2 (A8-2); REMOVED SECTION A-A (NO LONGER REQUIRED); REVISED D4154-1F	MB	11.04.05
A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AJS		
CHECKED	SP	DRAWING NO.	REV. E
MFG. APPR	N	D4154	SHEET 1 OF 4
APPROVED	SP	TITLE	SCALE
DE APPR.		WEARPLATE ASSEMBLY	NTS
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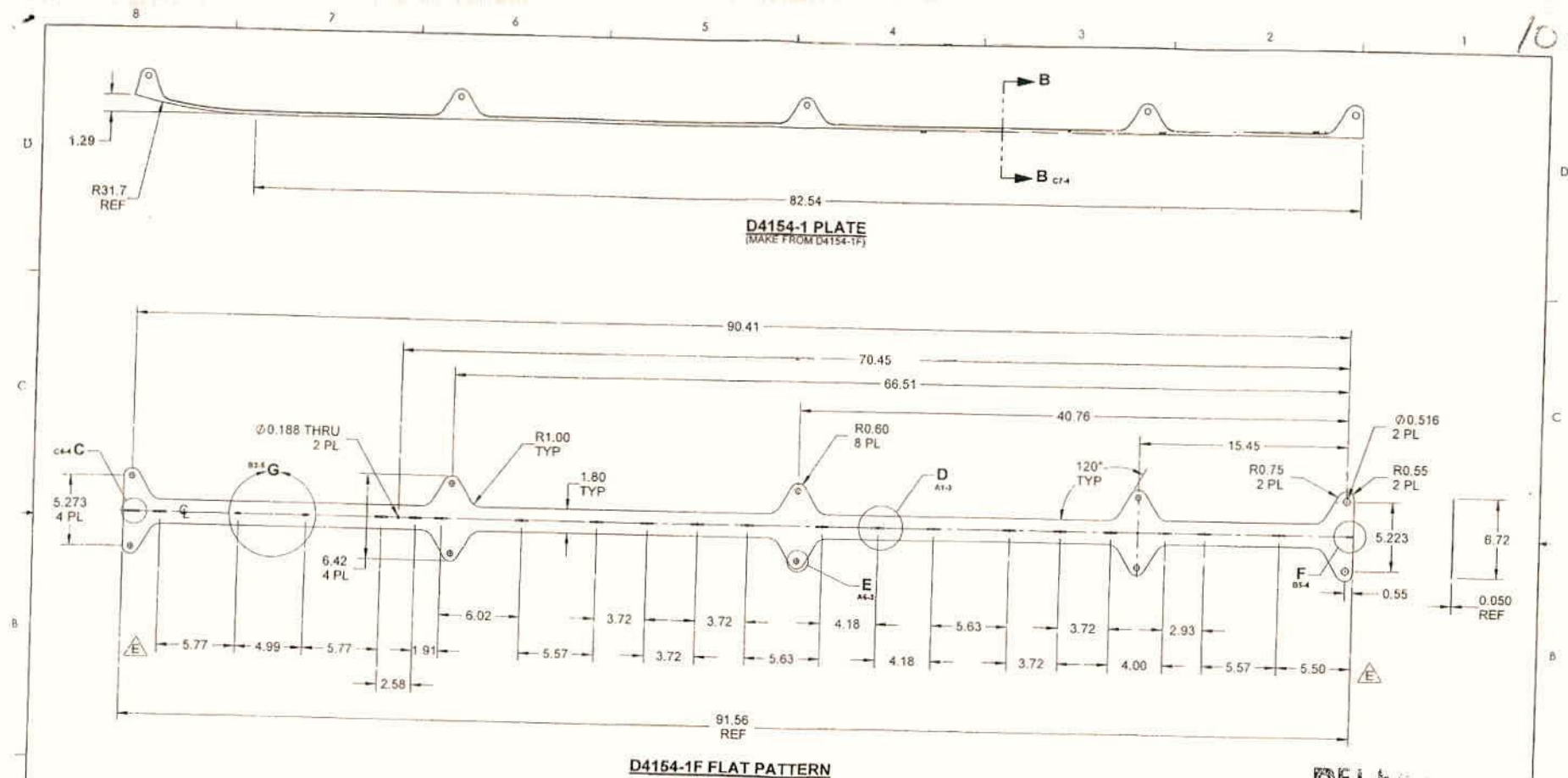
D4154-041 WEARPLATE ASSEMBLY

RELEASE
2012-09-04

- NOTES
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 015 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 7.75 lbs
 - 8) WELDING: PER QSI 004
 - 9) 2059B HARDCOAT WELD, 0.32 THICK x 0.50 WIDE, FLUSH WITH D4155-1 BAR ON LATERAL SURFACES, 9 PL Δ
 - 10) TRANSFER DRILL ϕ 0.188 HOLES FROM D4154-1 PLATE TO D4155-1 BAR
 - 11) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
 - 12) FORM TO MATCH PROFILE OF D4154-1 AT TIME OF WELDING

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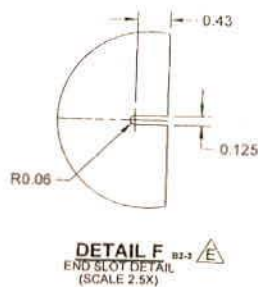
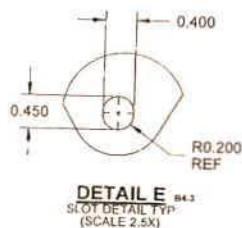
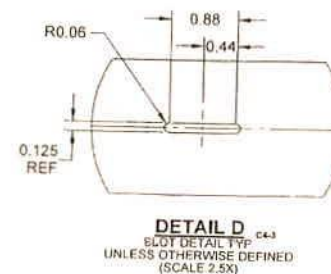
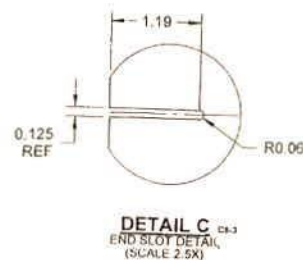
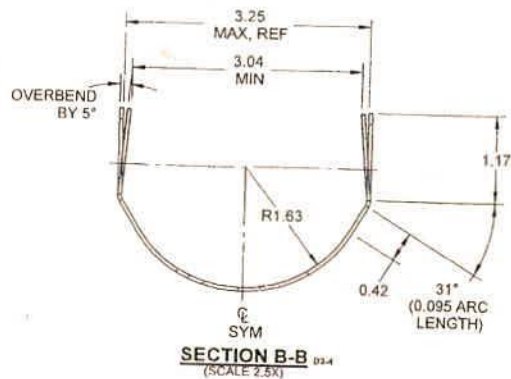
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NOTES

- 1) MATERIAL : AISI 304/316 STAINLESS STEEL PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH : NONE
- 3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS : INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
- 6) IDENTIFICATION : NONE
- 7) WEIGHT : 2.95 lbs

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CHECKED	JP	DRAWING NO.	REV. E
MFG. APPR.	JS	D4154	SHEET 3 OF 4
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